

**Work Order ID 67124**

Wednesday, March 09, 2011 8:41:35 AM

Page 1

Item ID: D3480-3

Accept

Revision ID:

Item Name: Tube

Start Date: 3/9/2011 Start Qty: 4.00

Required Date: 3/11/2011 Req'd Qty: 4.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3480

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D3480

304 . 018

C  
C  
1

B11-3-9

(9)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-3-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/09

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 67124**

Wednesday, March 09, 2011 8:41:35 AM



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Item ID: D3480-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 3/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00				(9x)			
Small Fab	Memo	0.00							
Small Fab	1-Roll as per dwg D3480□2-Spot weld as per dwg D3480□3-Debur								
									⇒ m.t 11/03/10
140  QC	QC11- Inspect spot weld per QSI004	0.00							
Quality Control	Memo	0.00							SB 11/03/10 (9)
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							SB 11/03/10 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 67124

Wednesday, March 09, 2011 8:41:35 AM



Page 3

Item ID: D3480-3

Accept



Setup Start



Revision ID:

Item Name: Tube

Stop



Start Date: 3/9/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Identify as per dwg & Stock Location: 61

0.00



Packaging

Memo

0.00

Packaging

11/3/10 90

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10 90

PL 11-03-10  
(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 8:41:32 AM

Page 1

Work Order ID: 67124

Parent Item: D3480-3

Parent Item Name: Tube



Start Date: 3/9/2011

Required Date: 3/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev. A 06.02.07 new issue EC  
IPP Rev B ☐ Now on Water jet 06.04.18 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S26GA

Purchased

No

sf

47.3100

0.240120



304/316 0.018 SHEET

113 11-309

Location

Loc Qty

Loc Code

MAT20

47.31

109398

16.06

112885

31.25

109398

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

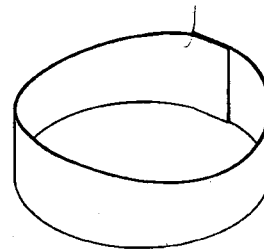
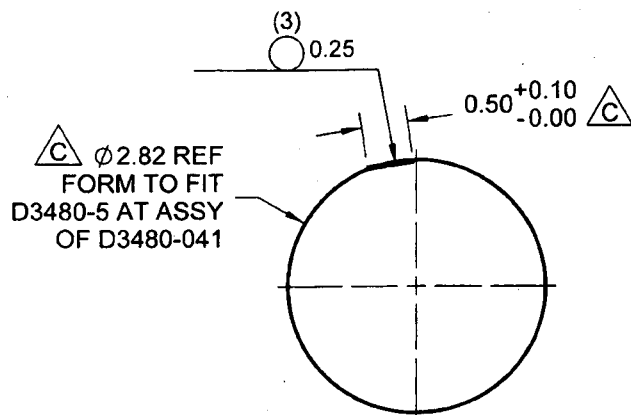
**NOTE:** Date & initial all entries



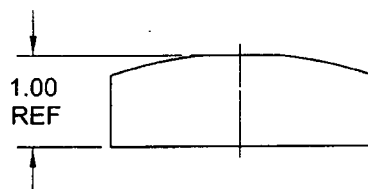


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3480</b>	REV. C SHEET 4 OF 6
DATE <b>08.12.19</b>		TITLE <b>EYEBALL ADAPTER</b>	SCALE 1:2

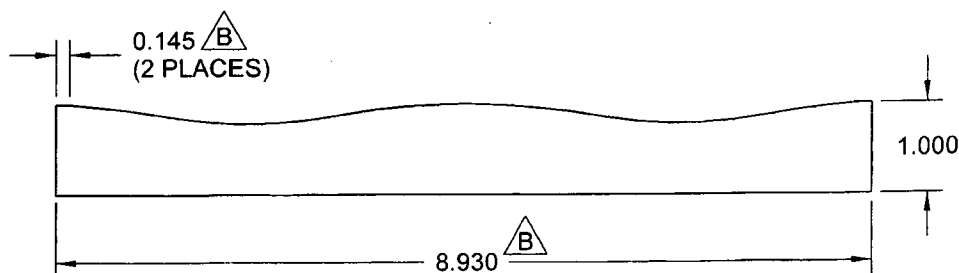
**RELEASE**  
9/6/30 MD



*W/067124*



### **D3480-3 TUBE**



### **D3480-3F TUBE FLAT PATTERN**

#### **NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5059 (ANNEALED) 2B FINISH  $\triangle C$   
OR AMS 5513/5524, 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	6-1029
<b>Description: Tube</b>		<b>Part Number:</b>	D3480-3
<b>Inspection Dwg: D3480</b>	<b>Rev: B</b>		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>RB</u>	Audited by: <u>D</u>	Prototype Approval: <u>N/A</u>
Date: <u>11-3-9</u>	Date: <u>11/03/09</u>	Date: <u>N/A</u>

Rev	Date	Change	Revised by	Approved
A	06.10.06	New Issue	KJ/JLM	
B	07.04.27	Dwg rev. updated	KJ/JLM	

# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 93

EMPLOYEE: Maie Gregory

PART NUMBER: D 3480-3

JOB NUMBER: B 67124

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: 0.10

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 11/03/16

QUALIFIER: SB